

# Work Order ID 66980

Thursday, March 03, 2011 9:02:43 AM



Page 1

Item ID: D3914-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 3/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: CY

Date: 11/03/03 Tooling:

Date: \_\_\_\_\_

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3914  
2- debur and remove identification markings

SAD 11-03-09

(4)

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

SAD 11-03-09

(24)

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 11-03-09

(4)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 66980**

Thursday, March 03, 2011 9:02:44 AM



Page 2

Item ID: D3914-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 3/3/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10  
C21103110

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

Thursday, March 03, 2011 9:02:40 AM

Page 1

Work Order ID: 66980

Parent Item: D3914-7

Parent Item Name: Rib





Start Date: 3/3/2011

Required Date: 3/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as  
per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 11.01.18 chg  
qc5 to 6 DD verf:EC

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit   | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M304TS0.500W.049  |                        | Purchased     | No          |                     |                  | 100             | f                  | 127.4721       | 7.875   | 33.15789     |               |                |        |
|  |                        |               |             |                     |                  |                 |                    |                |  | SAD 11-03-09 |               |                |        |
| Square Tubing   |                        |               |             |                     |                  |                 |                    |                |   |              |               |                |        |

Location

Loc Qty

Loc Code

MAT

127.4721358

114004

0

114807

3.579E-05

116610

127.4721

WA

0.00001

114724

0.00001

33.1579

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

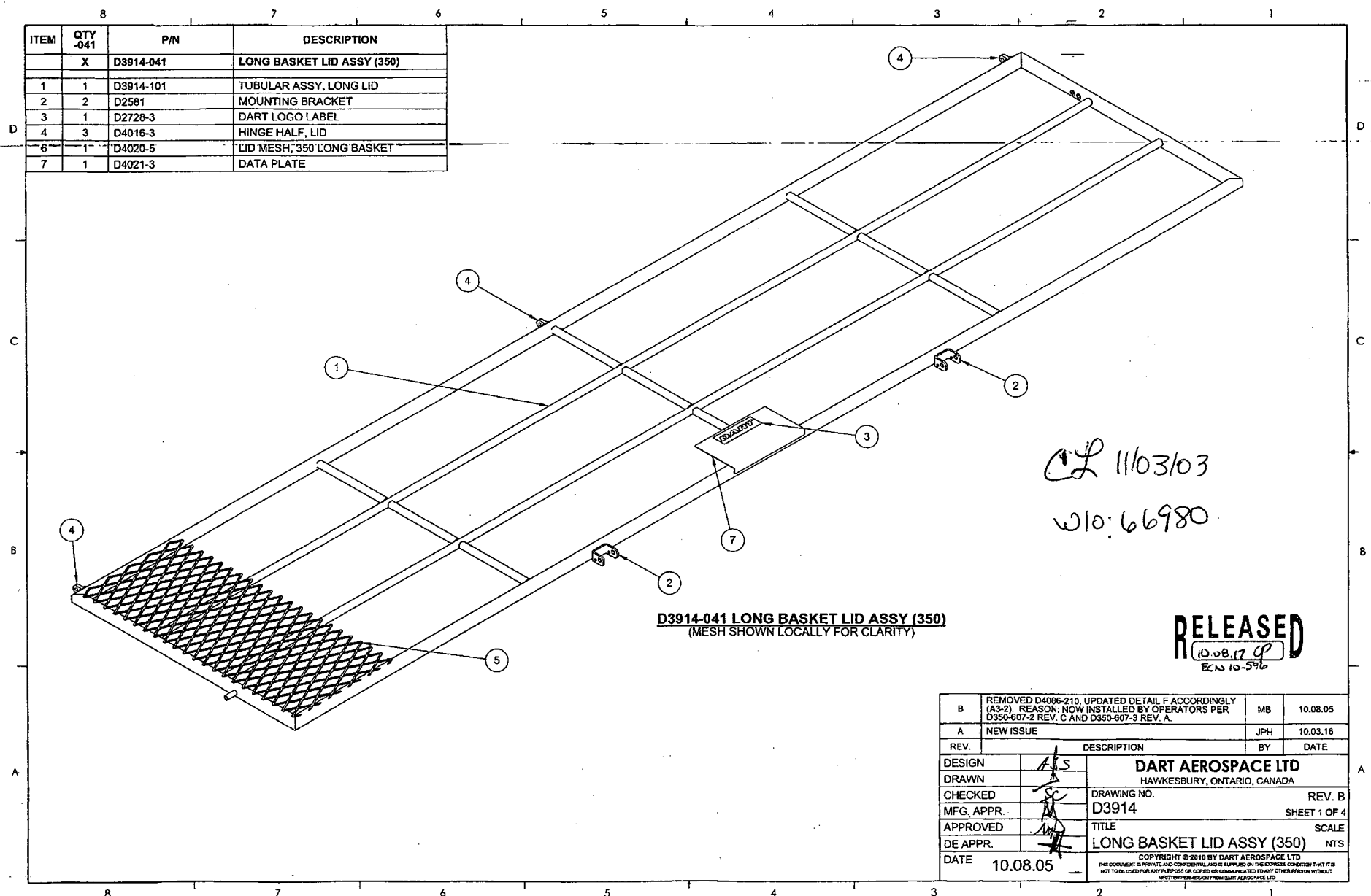
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

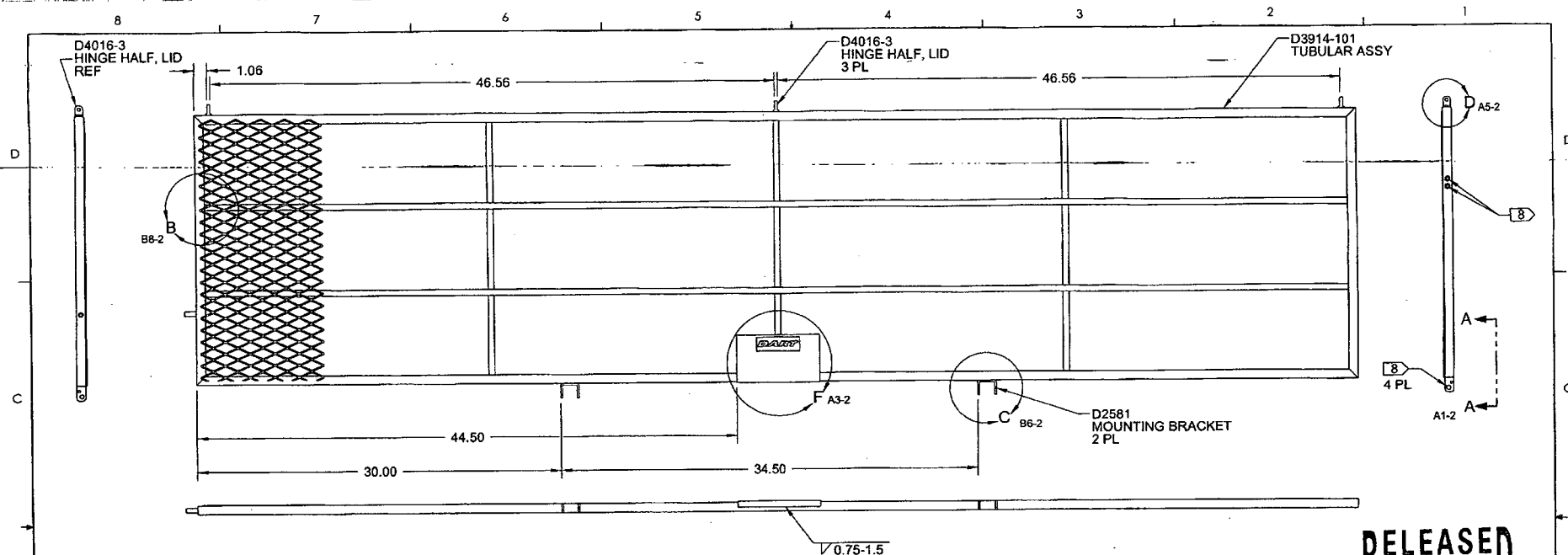
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

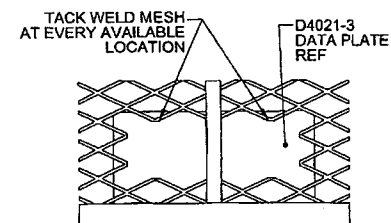
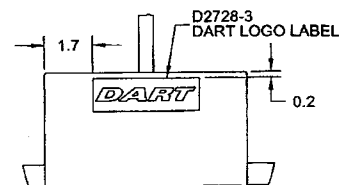
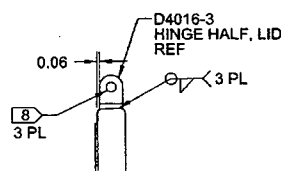
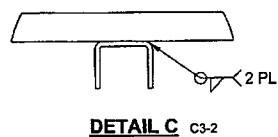
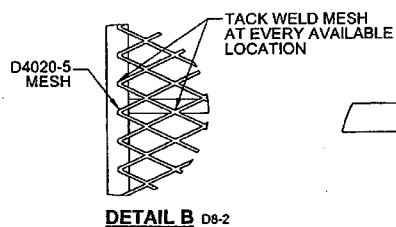
| ITEM | QTY<br>-041 | P/N       | DESCRIPTION                |
|------|-------------|-----------|----------------------------|
|      | X           | D3914-041 | LONG BASKET LID ASSY (350) |
| 1    | 1           | D3914-101 | TUBULAR ASSY, LONG LID     |
| 2    | 2           | D2581     | MOUNTING BRACKET           |
| 3    | 1           | D2728-3   | DART LOGO LABEL            |
| 4    | 3           | D4016-3   | HINGE HALF, LID            |
| 6    | 1           | D4020-5   | LID MESH, 350 LONG BASKET  |
| 7    | 1           | D4021-3   | DATA PLATE                 |





**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
10-08-12 UP



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

W/0: 66980

|            |          |                                   |              |
|------------|----------|-----------------------------------|--------------|
| DESIGN     | AJS      | <b>DART AEROSPACE LTD</b>         |              |
| DRAWN      | SC       | HAWKESBURY, ONTARIO, CANADA       |              |
| CHECKED    | WJ       | DRAWING NO. D3914                 | REV. B       |
| MFG. APPR. |          |                                   | SHEET 2 OF 4 |
| APPROVED   |          | TITLE                             | SCALE        |
| DE APPR.   |          | <b>LONG BASKET LID ASSY (350)</b> |              |
| DATE       | 10.08.05 | NTS                               |              |

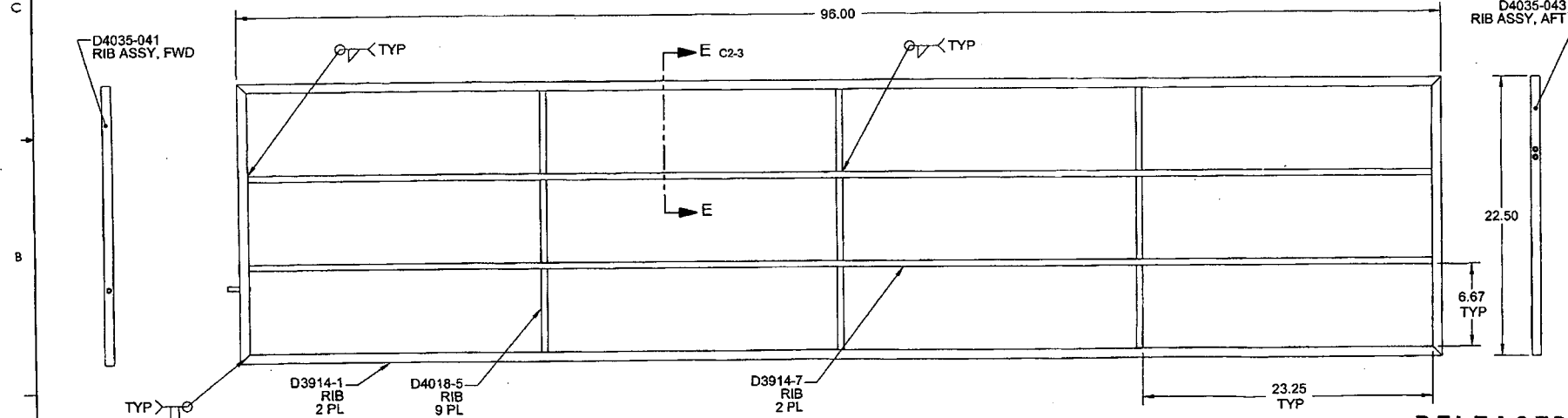
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| ITEM | QTY<br>-101 | P/N       | DESCRIPTION                  |
|------|-------------|-----------|------------------------------|
|      | X           | D3914-101 | TUBULAR ASSY, LONG LID (350) |
| 1    | 2           | D3914-1   | RIB                          |
| 2    | 2           | D3914-7   | RIB                          |
| 3    | 9           | D4018-5   | RIB                          |
| 4    | 1           | D4035-041 | BASKET LID RIB ASSY, FWD     |
| 5    | 1           | D4035-043 | BASKET LID RIB ASSY, AFT     |



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED  
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

W10'66980

|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   | ALS      | DART AEROSPACE LTD                     |              |
| DRAWN  |          | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  | RC       | DRAWING NO.                            | REV. B       |
| MFG. APPR.   | M        | D3914                                  | SHEET 3 OF 4 |
| APPROVED   | M        | TITLE                                  | SCALE        |
| DE APPR.   | M        | LONG BASKET LID ASSY (350) NTS         |              |
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